



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RB6795590

Job Sheet 197252



Part No: RB6795590

Job Qty: 1 pcs

Part Name: Puller-Bearing-Gas Producer & Power Turbine



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/19

Job Tracking No:

Due Date: 8/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 16098

Note: DWG RB6795590 Rev. 8 IPP Rev. A 19.06.06 New issue DP Verify DD

Ship Via:

DAS
03
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	8/2/19		0.00	0.17	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	8/2/19		0.00	0.00	QC 5 - 10		BAS 61 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	8/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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Container No: S219919



Part: RB6795590

Job No: 197252

Serial No/Batch: S219919

Revision: J

Inspector:

Exp Date:

Instructions:

Date: 10/04/19

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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	8/2/19	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9-59

DAS

GA139

OCT 07 2019

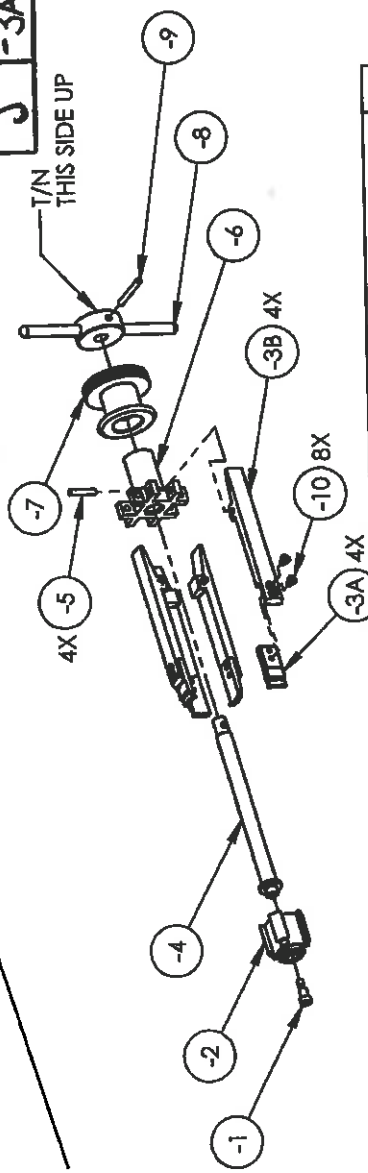
Part Op 100 - (Small Fab) 1-Assemble as per drawing. 2-Ensure proper positioning of tool number.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
70 91259A535	Socket Head Shoulder Bolt Ø1/4 X 3/8, 10-24	1 (1 ea)	100-Small Fab - 1	3198260
42 98381A510	Pin	4 Ea (4 ea)	100-Small Fab - 1	5075952
42 98381A514	Tee Handle Dowel Pin Ø3/16 X 1-1/2	1 (1 ea)	100-Small Fab - 1	5198287
139 RB6795590-10	Flat Head Socket Cap Screw	8 pcs (8 ea)	100-Small Fab - 1	5199968
139 RB6795590-2	Shoe	1 pcs (1 ea)	100-Small Fab - 1	5197689
139 RB6795590-3A	FINGER TIP, BEARING PULLER; GAS PRODUCER TURBINE, POWER TURBINE & COMPRESSOR	4 pcs (4 ea)	100-Small Fab - 1	5197724
139 RB6795590-3B	FINGER, BEARING PULLER; GAS PRODUCER TURBINE, POWER TURBINE & COMPRESSOR	4 pcs (4 ea)	100-Small Fab - 1	5197710
139 RB6795590-4	Jack Screw	1 pcs (1 ea)	100-Small Fab - 1	5197591
173 RB6795590-6	Adjusting Screw	1 pcs (1 ea)	100-Small Fab - 1	5197694
139 RB6795590-7	Adjusting Nut	1 pcs (1 ea)	100-Small Fab - 1	5197677
173 RB6795590-8	Tee Handle Weldment	1 pcs (1 ea)	100-Small Fab - 1	5200372

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91259A535	1	0	0
	98381A510	4	44	0
	98381A514	1	0	0
	RB6795590-10	8	0	0
	RB6795590-2	1	0	0
	RB6795590-3A	4	6	0
	RB6795590-3B	4	0	0
	RB6795590-4	1	0	0
	RB6795590-6	1	0	0
	RB6795590-7	1	0	0
	RB6795590-8	1	0	0
Part Specifications				
Specifications could not be found.				

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[illegible]

STOPS
PAPER
ENGINEERING

1972Z MO-
4270-57

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	-1	1	SOCKET HEAD SHOULDER BOLT	STEEL	Ø1/4 X 3/8, 10-24 (MCMASTER-CARR #91259A535)	1
			-2	1	SHOE	BRASS		2
			-3A	4	FINGER TIP	01		3
			-3B	4	FINGER	4140/4142		4
			-4	1	JACK SCREW	4140/4142		5
		B/O	-5	4	FINGER DOWEL PIN	STEEL	Ø3/16 X 1 (MCMASTER-CARR #98381A510)	1
			-6	1	ADJUSTING SCREW	4140/4142		6
			-7	1	ADJUSTING NUT	BRASS		7
			-8	1	TEE HANDLE WELDMENT			8
	X		-8A	1	TEE HANDLE CENTER	A36/1018/1020 HR		9
	2		-8B	1	TEE HANDLE ROD	A36/1018/1020 HR		10
		B/O	-9	1	TEE HANDLE DOWEL PIN	STEEL	Ø3/16 X 1-1/2 (MCMASTER-CARR #98381A514)	1
			-10	6	FLAT HEAD SOCKET CAP SCREW	STEEL	B-32 X 5/16 (MCMASTER-CARR #91253A190) MODIFIED	11
ASSY QTY								



PART
AEROSPACE

TITLE BEARING PULLER; GAS PRODUCER
TURBINE, POWER TURBINE & COMPRESSOR

DWG NO. RB6795590

REV 3

UNLESS OTHERWISE SPECIFIED:

ALL DIMENSIONS ARE IN INCHES

FRACTIONS 3/16

XXX .015

XX .01

X .005

ANGLES 3.8°

SURFACES = 125

1. BREAK ALL SHARP EDGES

2. DIMENSIONAL LIMITS APPLY

3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

DRAWN BY: PERRITT

CHECKED: DUERFELDT

DPPS APPR: ANDERSON

QA APPR: LINDSAY

APPROVED: *W*

SCALE 1:8

DATE 4/11/2008

SHEET 1 OF 11



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____		DISPOSITION		DEPARTMENT/PROCESS				MRB (Q51042)			
Part No. _____		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality	
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition					
Description Work Order Deviation		Completed By									
		Lead hand / Supervisor									
		QC / QA Coordinator									
Root Cause		FAULT CATEGORY									
Operator		Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong			
Manufacturing Process		Bending		Misaligned/off center		Folio/Program		Outside Tolerance			
Equip/Tooling		Crushing		BOM/Route		Grain Direction		Drawing			
Handling/Preservation		Cracks		Broken/Damage/Defect		Weld		Finish			
Material		Crimp/kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing			
Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence		Misread			
Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up					
Human Factors		Other/Details:									